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Weldwood® Doors

product of United States Plywood



Weldwood Doors



Weldwood Algoma Architectural Plain Sliced Walnut wall panels and doors in Executive Division Lobby, Southland Life Insurance Co., Southland Center, Dallas, Texas.

architect: Welton Beckett, FAIA, & Associates
installation: Adleta Show Case & Fixture Mfg. Co.

Sturdy and stable Weldwood Doors have long been preferred by architects, designers and owners for interiors and exteriors of all types of buildings. Countless thousands have been produced for residences, apartment and office buildings, schools, motels, hotels, hospitals, stores, restaurants — even for factories and gasoline stations.

The reputation of Weldwood Doors is the direct result of their performance.

VARIETY

Complete door schedules can be filled by United States Plywood, with doors supplied machined and finished for each opening. For the desired balance of appearance and wear-resistance, there is an appropriate hardwood, plastic or paint-grade face . . . and an engineered door construction.

faces	cores				
	mineral	lumber	hollow	acoustical	fire-rated
hardwood	•	•	•	•	•
plastic	•	•	•		•
paint-grade	•	•	•		
metal-reinforced	•	•	•		
special	•	•	•	•	

▲ — Weldwood Algoma-Made Doors

The criterion for the industry, these doors are particularly recommended for use wherever superior appearance, 'feel', and outstanding performance are requisites.

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GUARANTEES

The quality of each Weldwood Door is the direct responsibility of United States Plywood. Each is specifically guaranteed for performance and structural integrity.

SAMPLES

Veneer samples (of domestic and exotic hardwoods) and corner samples cut from actual Weldwood Doors, are available from United States Plywood.

SHOWROOMS

Weldwood Doors may be seen at United States Plywood executive offices in New York, at all branch offices, and at Architects Samples Corporation, 101 Park Avenue, New York.

Algoma-Made **Weldwood Doors** Custom-tailored for every opening

Certain 'standard' Algoma-Made Doors (particularly in Birch and Duraply faces) are normally in branch warehouse stock. Many, however, are made on order at Weldwood's Algoma, Wisconsin, woodworking plant to satisfy architects' specifications and door schedules.

This page shows a few of the many so-called 'special' requirements that are readily met by Algoma production.

Other Algoma-Made **WELDWOOD DOORS** for your special design needs

Custom Royal Door — with rugged, colorful Micarta® faces on "Stay-Strate", Staved Lumber Core, or Fire Door constructions.

Staved Lumber Core Door — all-purpose architectural door for interior-exterior residential, industrial, and institutional uses.

Special-Purpose Doors—Metal-reinforced Flush, X-Ray (lead lined), Louver, Hospital (with stainless steel stretcher and kick plates).

Architecturally-Designed Doors—Doors with Gothic, segment, and circle-top heads, as well as special light openings, etc., consistent with the architects' desire for the unusual.

Algoma Finishing, **Algoma Machining**

It is indicated more and more often that the craftsmanship of finishes and installers determines the satisfactory appearance and performance over the life of the hardwood-faced doors.

Weldwood Algoma factory finishing and machining assures the architect that each complete door — appearance, hanging, and construction — is in exact keeping with his door schedule.

Factory Finishing

For Permagard permanently-fused protective films, see pages 4 and 5. For lacquer and conversion varnish finishes, and for custom-finishing to architects' specifications, see page 6.

Factory Machining

For full information on the scope of Algoma fitting and machining, see page 7. For standard light and louver details, see page 8.



FIRE PROTECTION Weldwood hardwood-faced or plastic-faced Fire Doors have incombustible Weldrok® cores and treated edges, etc., stop both flame and destructive heat... are labeled as rated by Underwriters' Laboratories, Inc., for Class "B" (vertical shaft) and Class "C" (room and corridor) openings.



EXTRA-WIDE Current demands for residential entrances up to 4 feet wide require the stability, strength, and soundness of Weldwood Stay-Strate® Door. Has Weldrok mineral core, faced with any of a wide range of beautiful hardwood faces, with matching edges.



HEAVY-TRAFFIC DURABILITY Weldwood Permagard (TM) (see pages 4, 5) is a tough, invisible resin compound film. Permanently fused to natural hardwood faces of Algoma-Made Doors, it offers unprecedented resistance to scuffing and staining; protects wood's original beauty under heavy-duty wear.



SUPERB PAINT RETENTION Weldwood Duraply® Exterior Doors minimize paint failures, need only 2 coats of quality paint for colorful, all-weather beauty that lasts up to 5 years.



SOUND CONTROL Installed Weldwood wood-faced Acoustical Doors comply with Sound Transmission Classes 36, 40, and 51. They are as easily hung as any Weldwood Algoma-Made Door, ensuring economies of installation not ordinarily enjoyed with acoustical doors.

Weldwood® Permagard™ Doors

Thermoplastic-surfaced hardwood-faced doors

Shows the true appearance of natural wood.
Made only by United States Plywood.

Permagard-surfaced hardwood doors maintain their original beauty despite punishment of heavy traffic areas... with no need for waxing or resurfacing. Invisible when fused to the wood, (0.003") Permagard has far greater resistance to abrasion, acids, staining, and heat than conventional finishes have.

ADVANTAGES

- Four times more abrasion-resistant than high pressure laminates
- Highly resistant to staining
- Faithfully maintains the natural color of the wood face
- Eliminates on-site finishing
- Cleaned with damp sponge or cloth
- Worked with ordinary tools
- Available on all species of Algoma-Made hardwood-faced doors.



Life-Of-The-Building Warranty

The structural integrity of each base panel or door, and the adhesion of the protective clear plastic surface thereto, are guaranteed* by United States Plywood Corporation for the useful life of the building in which it is originally installed. Should any Weldwood Permagard-surfaced panel or door fail structurally, or should the surface film delaminate, the affected Permagard-surfaced panel or door will be replaced free of charge (or, at the option of United States Plywood, the cost price will be refunded), following (1) written claim by the owner or architect and (2) inspection and approval of such claim by a responsible representative of United States Plywood Corporation.

Reference is made to the separate guarantee of Weldwood Algoma-Made Plywood Panels and Weldwood Algoma-Made Hardwood-faced doors.

*—For interior applications only

SUGGESTED SPECIFICATIONS

Short Form:

Weldwood Algoma-Made Doors, as indicated, shall be finished with Permagard as manufactured by United States Plywood Corporation.

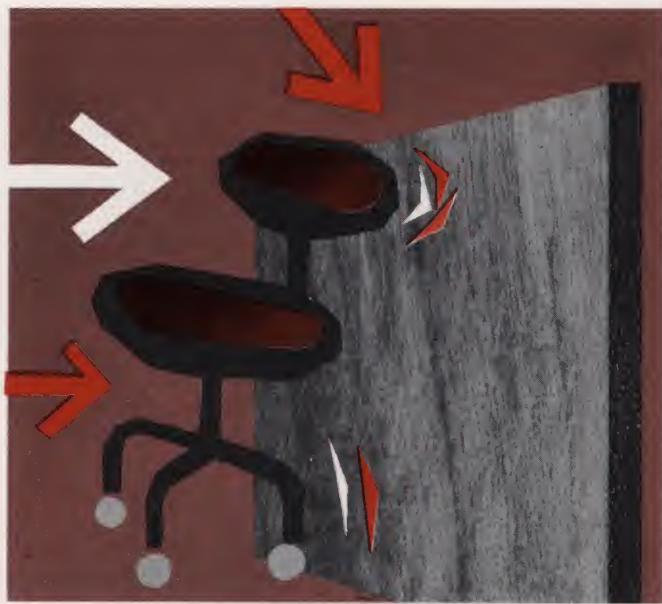
Long Form:

Faces: All Weldwood Algoma-Made Doors, as indicated, shall be finished with Permagard, consisting of 0.003" transparent thermoplastic polyester film, bonded to face of door under heat and pressure. Adhesive to fuse Permagard film to doors shall be a blend of polyester resins and solvents as manufactured by United States Plywood Corporation.

Edges: Polyester-polamine finish shall be factory-applied. For finish in the field, all edges shall be sanded smooth and dusted off. Three coats of Satinlac®, as manufactured by United States Plywood, shall be applied, sanding lightly between first and second coats. Steel wool (00) final coat when dry.

Weldwood Permagard

... protects hardwood door faces



Has four times the abrasion-resistance of high-pressure plastic laminate, best grade, of equal thickness, on comparable core, by standards of NEMA LP-2-205 tests. Permagard doors resist scuffing that would permanently mar ordinary finishes.



As stain-resistant as glass. Not affected by nail polish, oil base paints, crankcase oil, alcohol, etc. — as tested by standards of NEMA LP-2-205 tests. Most staining agents are washed off completely with household detergent or lacquer thinner, leaving no discoloration.



Age-resistant. Heat, cold, and humidity — in prolonged exposures or rapid cycles — show no effect on Permagard doors. Boiling water leaves no marks.



Permanently fused to the hardwood door face. Permagard film, 0.003" thick, is applied to the door face at the factory — a completely invisible, non-porous surface for the architectural hardwood-faced door.



Algoma-Made

Factory Finishing, (Cont'd)

Weldwood Factory Finishing assures uniform appearance — hardwood doors that are free from discoloration and will keep their “like-new” look for years, a more perfect match for all between doors. It permits using finishes that are difficult to apply in the field. It costs less than a medium-quality field applied finish. It largely eliminates weather and labor conditions as a factor in job progress. Finished doors will arrive at the job in protective paper bagging or cardboard cartons.

Weldwood factory-finished doors are most often ordered prefit and beveled to exact net size, and machined ready for hardware.

Machined and finished doors, being completely sealed, perform better, with no warpage.

WELDWOOD STANDARD PREFINISHING

Durable lacquer or conversion-type varnish is applied by skilled Weldwood craftsmen working in ideal finishing room conditions. The blemish-free clear finish will withstand more wear and exposure than most site finishing can assure.

Options:

A) Complete Finishing, Door Ready For Hanging.

3-Coat Finish — For close-grained woods such as Birch and Maple. Sealer and two top coats.

4-Coat Finish — For opened-grain woods such as Oak and Mahogany, includes filler and toner. Sealer, filler and two top coats.

B) Ready For Final Coat By Others.

Four edges and faces sealed and/or primed; sanded when specified.

WELDWOOD CUSTOM-FINISHING

Doors completely finished to architect's specification (or to match architectural plywood) with oil, pigmented lacquer, oil paint, plastic and other special finishes — according to each finish manufacturer's instructions.

IMPORTANT

For best performance of all doors, it is essential to finish both faces and all four edges immediately after door is fitted for opening and prepared for hardware. For interior doors we recommend Satinlac. Exterior doors should be finished with finishes recommended for exterior use.

RECOMMENDED SPECIFICATIONS FOR 4-COAT WELDWOOD ALGOMA FINISH

with either lacquer or conversion varnish

PREPARATION OF WOOD SURFACES

1. The final polishing shall utilize various grits to eliminate all sander marks and sander scratches. The polished surface shall be wiped clean prior to the application of the sealer coat.

FINISH

1. The finish shall consist of four separate and distinct coats: the sealer coat; the combination filler stain; and two separate coats of the final finish. Sealer coat shall be compatible with final coats specified.

2. The sealer coat shall be applied by spray or roller coater, permitted to dry to solid film and then lightly sanded.

3. The combination filler-stain shall be applied by spray or roller coater and fully padded into the surface and wiped off.

4. The final finish (as specified) shall consist of two coats of a clear, durable, scratch resistant lacquer or catalyzed conversion resin.

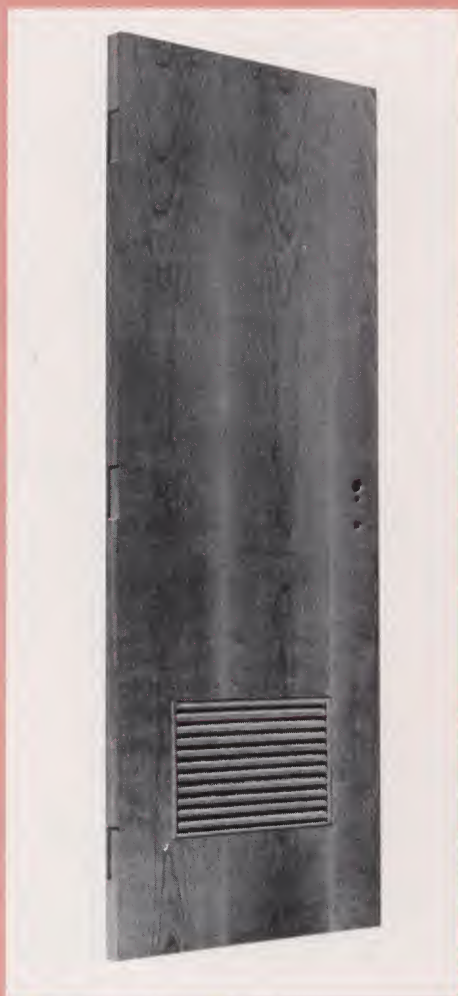
Note: For dense, close grained woods such as Birch and Maple, the combination filler-stain (step #3) may be eliminated at the customer's discretion for 3-Coat finish.

More architects are maintaining control of door hanging by ordering Weldwood Algoma-Made Doors Factory-Fit, and beveled to net opening size, and Factory-Machined to satisfy the entire hardware schedule.

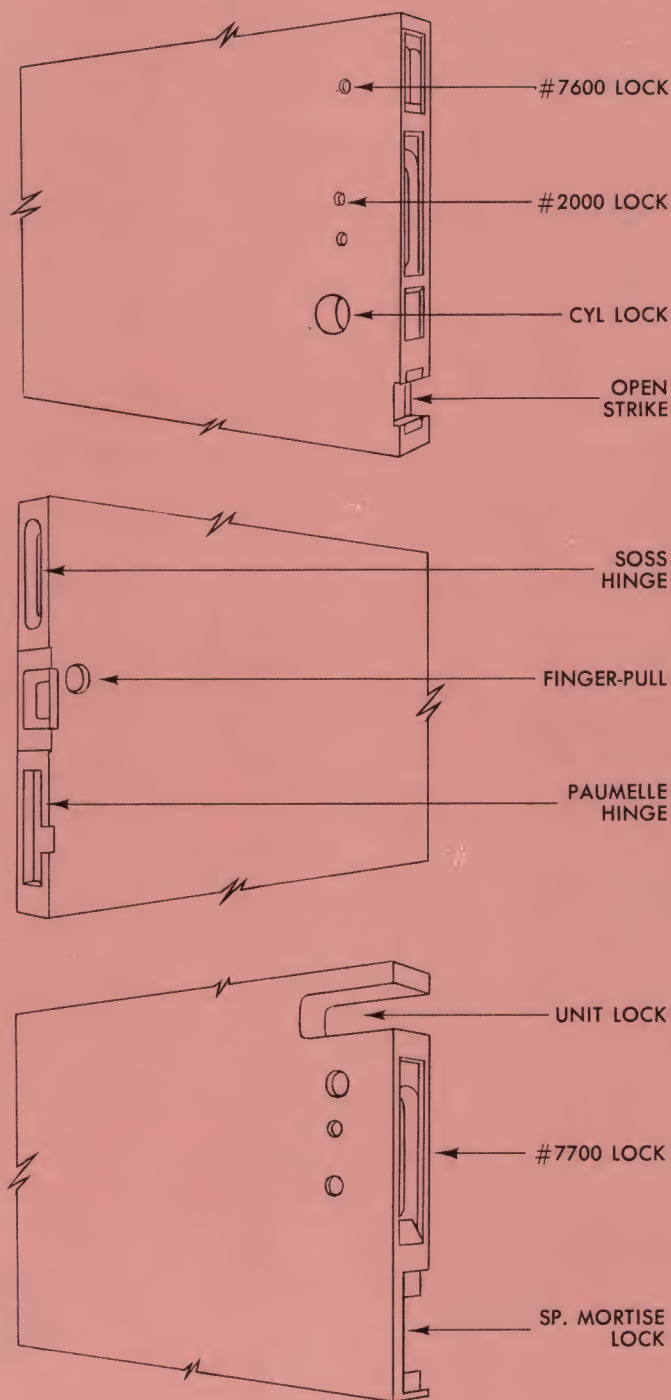
The doors are received directly from the factory, eliminating problems in adjustments for imperfect workmanship. Doors are trimmed properly, preserving the strength of stiles and edges. Delivery schedules are fulfilled.

When also ordered Factory-Finished, the completed doors arrive at the job all ready for hardware and installation.

Weldwood's Algoma, Wisconsin, plant is completely equipped to furnish doors in any quantity, matching supplied specification, dimensions and hardware schedule.



TYPICAL FACTORY MACHINING

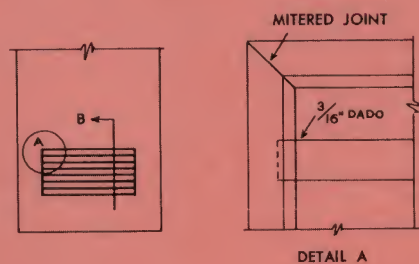
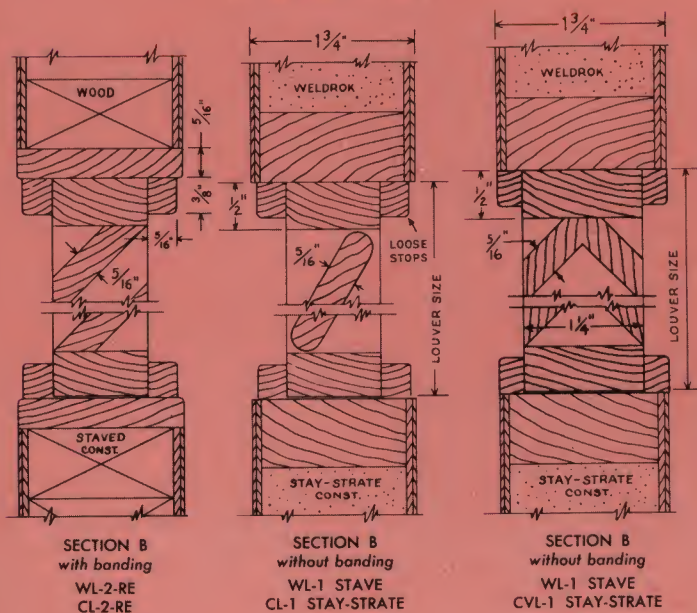


Weldwood Algoma-Made Doors can be provided at the factory with circular, rectangular and divided light openings and rectangular louver openings. Special light and louver openings are available to be consistent with architects' desire for the unusual.

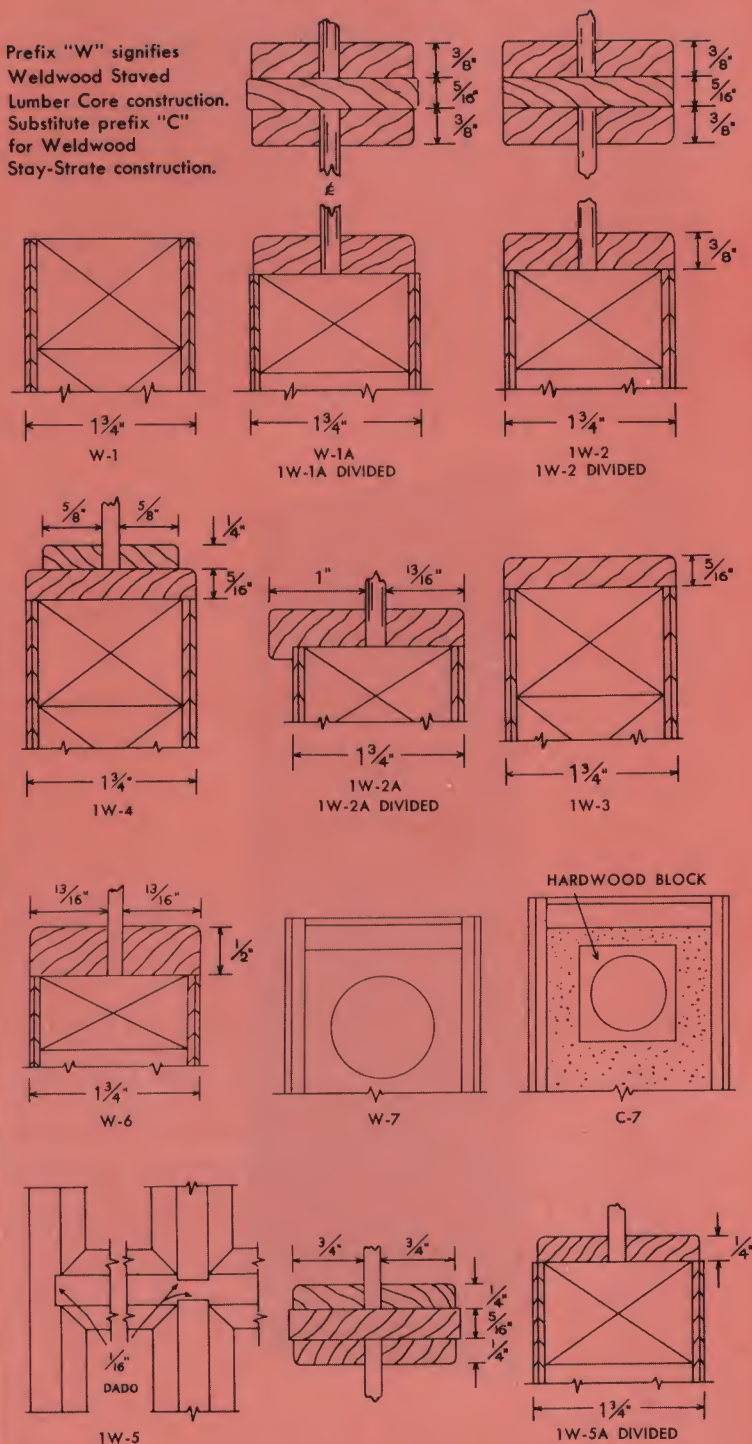
Wood louvers of species to match the face can also be installed. For light openings, glass beads are tacked loose in place. The following are typical for Weldwood "Stay-Strate" and Weldwood Staved Lumber Core Doors. Doors with unusually large openings shall be cut at the customer's risk.

Glazing and installation of metal louvers is by others.

TYPICAL CONSTRUCTIONS



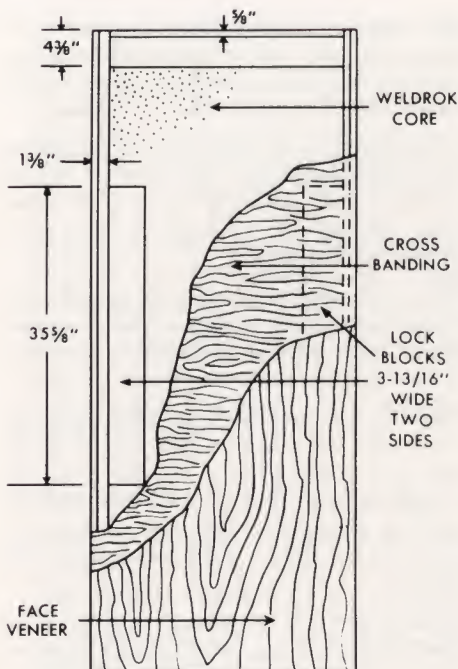
Prefix "W" signifies
Weldwood Staved
Lumber Core construction.
Substitute prefix "C"
for Weldwood
Stay-Strate construction.



Weldwood

"Stay-Strate" Door

For interior and exterior use in schools, hospitals, motels, hotels, churches, offices and apartment buildings, residences.



Has the elegant appearance and solid feel of a sturdy architectural door. Faces are Birch or other hardwoods selected for grain and color, or to match architectural woodwork.

Wood Faces: Standard thickness Birch and other hardwood veneers selected for grain figure and color, special faces to match architectural woodwork, or plastic (Custom Royal Door).

Weldrok® Core: Composed of calcium silicate with asbestos fibers. Nominal density: 22#. Identical to core of Weldwood Fire Door.

Hardwood Crossbands: 1/16" thick, kiln-dried, extending full door width.

Lock Blocks: 3-13/16"x35%", on 2 edges.

Adhesive: Faces and crossbands laminated to core with Type I 100% waterproof glue, applied by hot plate process.

Edge Bands: Top and bottom rails are thoroughly dried hardwood, total width 4 3/8". Stile edge bands are thoroughly kiln dried hardwood, total width 1 3/8". One piece exposed edges. Long edges may be same species as face veneer, at customer's option.

Light and Louver Openings: Available in accordance with Weldwood standard details.

Sizes: A wide range of sizes in 1 3/4" stock thicknesses. 2 1/4", 2", and 1 3/8" thick on special orders. Doors trimmed square to standard book sizes.

Fitting and Machining: On order, doors factory prefit and machined.

Finishing: Weldwood factory finishes or custom finishes, as specified.

SUGGESTED SPECIFICATIONS

All flush veneered doors (as indicated) shall be Weldwood "Stay-Strate" Veneer Doors, with Weldrok Core, as manufactured and guaranteed by United States Plywood Corporation. (See full guarantee)

Face Veneers: Face veneers shall be thoroughly kiln dried hardwood, laid with grain at right angles to the grain of the cross bands. Standard thickness sliced or rotary cut woods. (Insert species). Both faces shall be smoothly belt sanded. Doors may not always be ready

for painters' finish if subjected to excess humidity and rough handling during shipment and storage, and should be sanded lightly with 00 sandpaper before finishing.

Core: The core shall be made of Weldrok® with 22# per cubic foot nominal density. Each core shall be made of three or more pieces securely bonded together by the high frequency gluing process.

Crossbands: Crossbands shall be thoroughly kiln dried hardwood 1/16" thick, extending the full width of the door and laid with the grain at right angles to the face veneers.

Edge Bands: Top and bottom rails shall be thoroughly kiln dried stock, total width 4 3/8", built up of a net 3/8" hardwood outrail securely glued to a staved inner-rail of Pine or equal species. Side edge bands shall be thoroughly kiln dried hardwood, total width 1 3/8", built up of two (2) pieces of stock securely glued together. Exposed edges shall be one piece, and of same species as face veneer on the long edges, if specified.

Sizes: Doors shall be available in standard sizes up to 4/0 x 8/0. Large sizes up to 6/0 x 12/0 on special order subject to availability of face veneer. All doors shall be trimmed to standard book sizes. On order, doors can be prefit to exact size specified.

Thicknesses: 1 3/4" stock thicknesses. Also 2 1/4", 2" and 1 3/8" thicknesses on special order.

Adhesive: Crossbanding and faces shall be laminated to core with Type I 100% waterproof glue, by hot plate process, providing a door especially adapted for exterior use.

Lock Blocks: Lock blocks 3-13/16" wide, 35% long, shall be provided on two (2) edges. Inside edge of lock blocks shall be not less than 5-3/16" from outer edge of door. Minimum distance from bottom of lock block to bottom of door shall be 22-3/16". Wider lock blocks are available on order for special conditions such as back set locks.

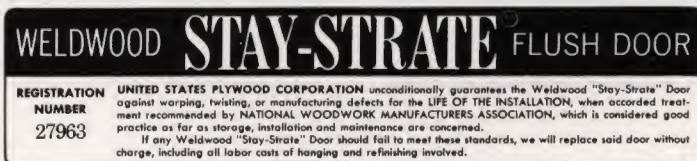
Light and Louver Openings: Where specified (indicate size and location) doors shall be provided with light and louver openings (with metal flashing if specified for exterior doors), in accordance with Weldwood details which include circular, rectangular and divided lights, and wood louvers. Glass beads for light openings shall be provided tacked in loose. All glazing and installation of metal louvers shall be done by others.

Note: Flush doors with light and/or louver openings over 40% of door size, are not guaranteed. The portion between cut-out area and door edges shall not be less than 5" wide at any point.

Finish: Factory machined and finished to your specifications.

Life of the Building Guarantee

The Weldrok core is so stable, that Weldwood "Stay-Strate" Doors are guaranteed for the life of the installation. Each door is registered by number and carries this label.

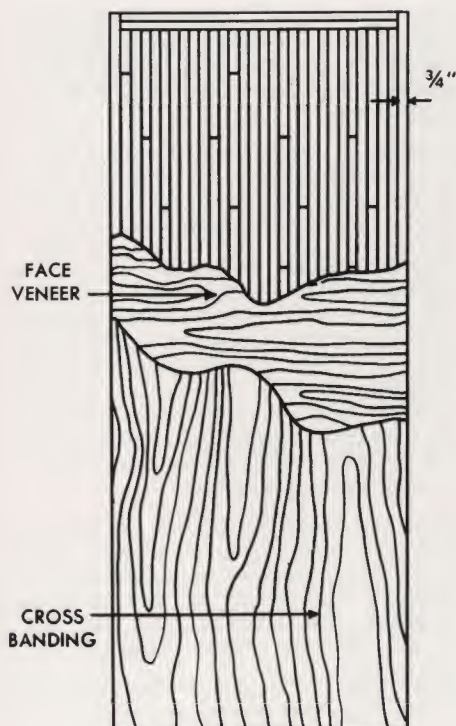




Algoma-Made

Weldwood Staved Lumber Core Door

The highest quality door of its type . . . all purpose, interior and exterior door, for hospitals, hotels, schools, churches, apartment and office buildings and residences. Particularly suited to match Algoma-Made plywood paneling.



The staved lumber, glued up core is constructed of varying length blocks of low density wood to provide a weatherproof door with unusually high strength/weight ratio.

Standard Thickness Face Veneers

Birch and a wide variety of other beautifully-grained hardwoods as well as special faces to match architectural wood-working.

Stock Sizes and Thicknesses

1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ ", 2" and 2 $\frac{1}{4}$ " thicknesses are available, as well as 1 $\frac{1}{8}$ " and 1 $\frac{1}{4}$ " stall doors. Life of the Installation Guarantee covers doors up to 4/0 x 7/0, which are normally considered stock. Sizes up to 6/0 x 12/0 are available, not covered by the standard guarantee.

SUGGESTED SPECIFICATIONS

All flush doors (as indicated) shall be Weldwood Staved Lumber Core Doors, as manufactured and guaranteed by United States Plywood Corporation.

Face Veneers: Face veneers shall be standard thickness, thoroughly kiln dried hardwoods and laid with the grain at right angles to the grain of the cross bands. Standard thickness sliced or rotary cut domestic or foreign woods. (Insert species and any special requirements). Both faces shall be smoothly sanded. Doors may not

be ready for painters' finish if subjected to excess humidity and rough handling during shipment and storage, and should be sanded lightly with 00 sandpaper before finishing.

Cross Bands: Cross bands shall be thoroughly kiln dried hardwood, 1/16" (or 1/10", where specified) thick, extending the full width of the door and laid with the grain at right angles to the face veneers.

Core: Core shall be glued up of properly kiln dried wood blocks (varied lengths of narrow pieces of pine or equal species). Hardwood core is available on specifications.

Edge Bands: The stile edge bands shall be thoroughly kiln dried $\frac{3}{4}$ " hardwood to match the faces. Top and bottom edge bands of two (2) pieces of $\frac{3}{4}$ " built up hardwood shall be applied. All edge bands shall be laminated to the core with Type I 100% waterproof resin glue.

Adhesive: Cross bands and faces shall be laminated to the cores with Type I 100% waterproof resin glue, by the hot plate process.

Sizes: Doors shall be available in a wide range of sizes and thicknesses. 1 $\frac{3}{8}$ ", 1 $\frac{3}{4}$ ", 2" and 2 $\frac{1}{4}$ " thicknesses are available, as well as 1 $\frac{1}{8}$ " and 1 $\frac{1}{4}$ " stall doors. The complete range of standard sizes can be furnished, up to a maximum of 6/0 x 12/0.

Prefit: All doors shall be trimmed square to standard book sizes, or prefit to net sizes.

Light and Louver Openings: Where specified (indicate size and location) doors shall be provided with light and louver openings (with metal flashing specified for exterior doors), in accordance with Weldwood details which include circular, rectangular and divided lights and wood louvers. Glass beads for light openings shall be provided tacked in loose. All glazing and installation of metal louvers shall be done by others.

Factory Machining and Finishing: May be specified.

NOTE: Doors with unusually large light openings should be detailed as stile and rail doors. Large light and louver opening areas shall be cut in a typical flush door at the user's risk.

Life of the Installation Guarantee

Weldwood Staved Lumber Core Doors are manufactured to the highest standards of the industry and under the most rigid quality controls. If treated in accordance with the best carpentry and finishing practices, the United States Plywood Corporation will guarantee against manufacturing defects and performance for the LIFE OF THE INSTALLATION.

Weldwood Doors must not be structurally impaired by excessive trimming or manufacturing. Immediately after fitting, they shall be finished with exterior or interior varnish as required, or painted on all four edges as well as the two faces. Should any Weldwood Staved Lumber Core Door prove unsatisfactory after installation, the United States Plywood Corporation agrees, after inspection by an authorized representative, to replace the door and allow costs of a reasonable nature for rehanging and finishing.

Weldwood Fire Doors

Hardwood and Micarta faced
for Class "B" and Class "C"
openings in hospitals, hotels, schools,
institutions, office and apartment
buildings, residences

Tested and rated by Underwriters' Laboratories, Inc. for fire resistance, heat transmission and structural integrity, and labeled for 1-Hour (up to 4'0" x 7'0") for Class "B" vertical shaft openings; for ¾-Hour (up to 4'0" x 8'0") for all Class "C" room and corridor partition openings.

Weldwood Fire Doors are light in weight. Original cost is moderate — and is especially appealing when the minimum up-keep record of the doors is considered. The hardwood or plastic faces require almost no care in ordinary use, and the incombustible Weldrok core maintains the doors straight and true.

Weldwood Custom Royal Fire Door

Combines durable, high pressure decorative plastic Micarta faces with dimensionally stable, precision-made Weldwood Fire Door. For Class "B" and Class "C" openings. Size limit: 4'0" x 7'0". No vision panels permitted.

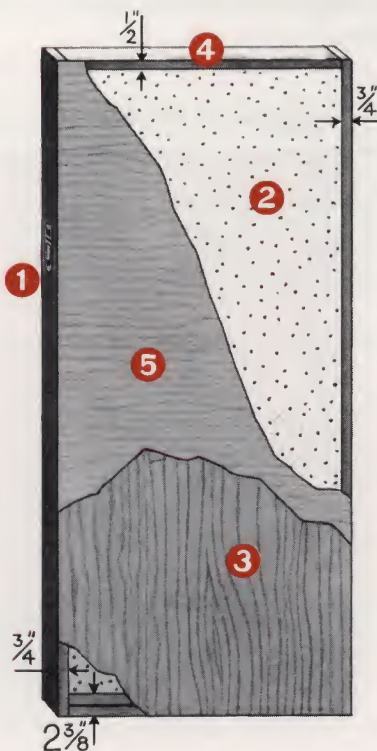
Weldwood ¾-Hour Fire Door For Class "C" Openings


The door is listed by Underwriters' Laboratories, Inc., for 45 minute fire barrier. It gives full protection against flame. Door is approved up to 4'0" x 8'0". Vision panels in 5 standard sizes: 18" x 24", 18" x 36", 24" x 30", 24" x 36", and 30" x 36". Special sizes are available on order as large as 30" x 36". Vision panels must be at least 6" from top edge and sides of door. Vision panels not approved in doors over 4'0" x 7'0".

Faces: Birch, Korina, Mahogany, Comb Grain Oak, and Walnut are standard. Many other fine hardwoods are available on order, and to match architectural woodwork. Weldwood Factory-Finish can be specified. For information on Micarta, see Weldwood Custom Royal Doors.

Sizes: All standard door sizes. Special sizes on order, up to 4'0" x 7'0". (Class "C" Fire Doors, without vision panels are available up to 4'0" x 8'0".)

Weight: 3.5 lb./sq. ft., approx.



1 APPROVALS—The combination Underwriters' Laboratories — Factory Mutual — United States Plywood Corporation metal label is firmly attached on hinge stile edge, ½ down from top of door. The Weldwood Fire Door is approved by Factory Mutual Laboratories , New York Board of Standards and Appeals (Approval Calendar No. 143-54SM), Building Officials Conference of America (BOCA 51-3A).

2 INCOMBUSTIBLE WELDROK CORE — The core construction of the door is made up of accurately-shaped sections of Weldrok, exclusive United States Plywood mineral core material, joined tongue-and-groove.

3 HANDSOME FACES — HARDWOODS: Standard Thickness hardwood (Birch, Oak, Walnut and many others) veneer. Other face veneer woods available. **PLASTIC:** Westinghouse Micarta®, **HI-DENSITY OVERLAID SURFACES:** Permaply®.

4 FIREPROOFED EDGE BANDING — All four door edges are banded with hardwood (Maple) that has been properly treated to refusal with Class "A" fireproofing agent.

5 HARDWOOD CROSS BANDING—Kiln-dried 1/16"-thick hardwood veneer cross banding is bonded to the Weldrok core with waterproof phenolic resin glue.

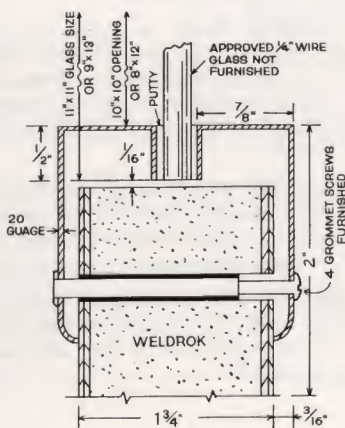
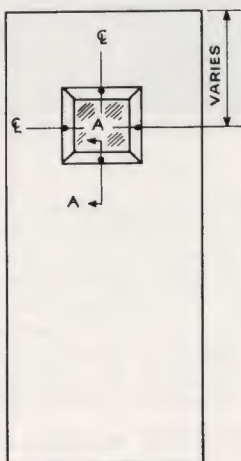
Weldwood Fire Doors (continued)



This metal label is fastened to the hinge stile edge of each Weldwood Class "B" Fire Door. Similar label for Class "C" Door shows "RATING: ¾-HOUR (C)."

VISION PANEL

When required, a vision panel frame for light openings can be provided, either factory installed or packed in a carton complete with screws. For Class "B" openings, three standard size light openings are available: 5" x 10", 10" x 10", and 8" x 12", which meet the maximum allowable glass area of 100 sq. in., as established by Underwriters' Laboratories. For Class "C" openings, vision panels are available in five standard sizes (or any special size, on order) up to and including 30" x 36".

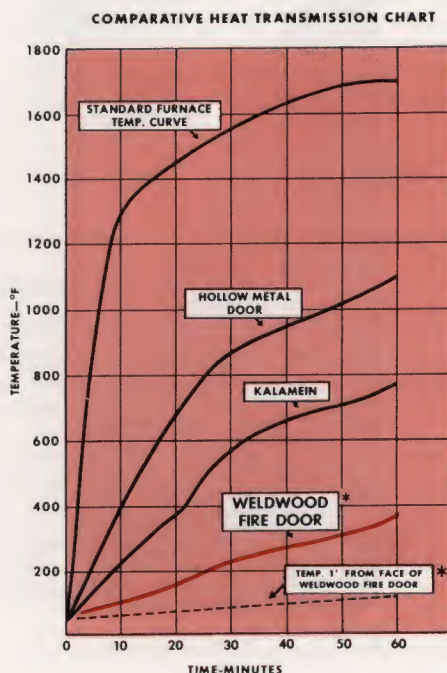


SECTION A-A

Low Heat Transmission

Weldwood Fire Door's extremely low rate of heat transmission provides a substantial margin of safety in the reduction of fire spread.

This chart, compiled from official tests, compares the heat transmission rate of a Weldwood Fire Door with those of hollow metal doors and Kalamein doors. It shows that in tests by Underwriters' Laboratories, Inc., the temperature rise of Weldwood Fire Door's unexposed face is less than 250°F, after 30 minutes in the test furnace, while the temperature rise in the test furnace is well over 1500°F. Moreover, after a full hour's exposure of one face to searing 1700°F flame, the temperature rise is only 120°F at only 1 foot from the unexposed face of the Weldwood Fire Door.



*Taken from fire test report Underwriters Labs Inc., Others from U. S. Senate hearings on safety at sea

Weldwood Fire Door Guarantee

United States Plywood Corporation unconditionally guarantees the Weldwood Fire Door against warping, twisting or manufacturing defects for the life of the installation, when accorded treatment recommended by NWMA, which is considered good practice as far as storage, installation and maintenance are concerned.

If any Weldwood Fire Door should fail to meet these standards, we will replace said door without charge, including all labor costs of hanging and refinishing involved.

SUGGESTED HARDWARE AND INSTALLATION

for Class "B" and "C" openings

The following covers recommended hardware for swinging, labeled hardwood or plastic faced Weldwood Fire Doors for both vertical shaft and corridor and room partition openings. (Doors can be Finished, Fit, and Machined for hardware, at the factory.)

Clearance: Maximum clearance: at sides and top, 1/16"; at bottom, ¼". Plane the lock stile edge only. (The Underwriters' label is one-third from the top of the hinge stile. The installed door must always have the label in this position.)

Important: Always trim for height from bottom edge, but never reduce height more than 1⅝". Never cut door width or height to fit smaller opening than the size for which the door is manufactured.

Lock Sets for Weldwood Fire Door: Lock and latch sets should be Underwriters' Laboratories approved and listed single point locks or latches with a minimum ½" 'throw bolt'. (See Underwriters' Laboratories Approved Building Materials list.) It is recommended that lock sets with screwless roses be used to avoid the very short rose attachment screws which may in time work loose.

Hinges for Weldwood Fire Door: Steel full mortise butt type hinges, are installed on hinge stile edge, the leaf of hinge applied to door to be secured with 1¼" x #12 flat head self-tapping sheet metal screws. When applying screws do not extend

pilot holes deeper than the thickness of the wood edge banding which is $\frac{3}{4}$ ". *Steel half surface hinges* are secured by bolting thru the door. Half surface hinges should be not less than $4\frac{1}{2}$ " x $4\frac{1}{2}$ ", made from not less than $\frac{1}{8}$ " steel and be of ball bearing type. *Butt hinges* should be not less than $4\frac{1}{2}$ " x $4\frac{1}{2}$ ", made from not less than $\frac{1}{8}$ " steel and be of ball bearing type.

Always use three of the above size hinges for all Weldwood Fire Doors. For doors 7' to 8' in height, four hinges are required by the Underwriters' Laboratories.

Door Closers: Certain concealed and semi-concealed closers are suitable for the Weldwood Fire Door, having been installed in the Weldwood Fire Door and tested satisfactory by Underwriters' Laboratories. It is recommended that the mortise opening in door for closer be sealed with shellac as soon as possible after cutting and that closers be secured in the top edge of the Fire Door with self-tapping sheet metal screws in place of the wood screws normally supplied. Surface-mounted door closers must be installed with through bolts.

Pivot-Type Hinges and Closer: Weldwood Fire Doors have been tested and approved by Underwriters' Laboratories, Inc., for hanging with malleable iron pivot-type hinges with door closer. Rixson Hardware: top surface mount pivot #280-F, intermediate pivot #FM-19, bottom pivots #117-F, or #117 $\frac{1}{4}$ -F, and uni-check

#65-F, 66-F, 67-F, 68-F, are currently listed by Underwriters' Laboratories for use with Weldwood Fire Doors.

Note: Pivot hinges not permitted for Custom Royal Fire Door.

Door Frames: All Weldwood Fire Doors should be installed in Underwriters' Laboratories labeled metal frames: 16 gauge for 3'6" width and under, 14 gauge for openings over 36". Consult hardware manufacturers' catalogs for finishes and any additional information.

When doors are to be installed in bucks of a net opening size, better results will be obtained if the door size is specified prefit $\frac{1}{8}$ " scant in width and 5/16" in height.

The fireproofing agent in stiles and rails is hygroscopic. All Weldwood Fire Doors are delivered with edges sealed. Immediately after fitting, edges should be sealed with Breining Brothers Knot Stop, or Western Pine Association Knot Sealer.

SUGGESTED SPECIFICATIONS

SHORT SPECIFICATION: All Class "B" 1-Hour (vertical shaft), or Class "C" $\frac{3}{4}$ -Hour (room or corridor), doors shall be Weldwood Fire Doors bearing UL Labels designating the rating, as manufactured by United States Plywood Corporation. All designated doors shall be flush or contain Vision Panels. Vision Panels can only be installed in door sizes up to 4/0 x 7/0. Glass by others.

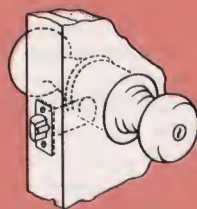
Faces: State veneers selected.

LONG SPECIFICATION: All Class "B" 1-Hour Fire Doors or Class "C" $\frac{3}{4}$ -Hour Fire Doors shall be Weldwood Fire Doors as manufactured by United States Plywood Corporation, bearing UL Labels. Faces shall be thoroughly dried standard thickness (specify veneer selected) laid at right angles to the grain of the cross band. Cross bands shall be thoroughly dried hardwood $\frac{1}{16}$ " thick extending full width of the door.

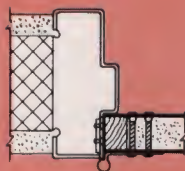
Core: Core shall be Weldrok (calcium silicate with asbestos fibers) 22# nominal density. Core shall be joined together with tongue-and-groove joints in accordance with Underwriters' Laboratories' procedure manual. Core to be smoothly sanded prior to application of cross bands and face veneer. Edge bands shall be hardwood treated with a Class "A" fireproofing agent. Top rail shall be $\frac{1}{2}$ " in thickness, stiles $\frac{3}{4}$ " in thickness, and bottom rail shall be $2\frac{3}{4}$ " in thickness. The core and edge banding shall be bonded together with a waterproof resin glue. The entire core shall be sized on two sides to insure perfect glue bond between core and cross band. The core cross band and face veneer shall be bonded with Type 1 waterproof phenolic glue by the hot plate process. When indicated on the plans, vision panels shall be installed. (Specify here size of vision panel desired.) Vision panels can be installed in door sizes up to 4/0 x 7/0. Glass to be $\frac{1}{4}$ " plate wire glass by others. All doors to be guaranteed against manufacturing defects and for performance for the life of the installation in accordance with manufacturer's guarantee.

Machining: All Weldwood Fire Doors can be factory-machined to accept all Underwriters' Laboratories approved hardware.

Finish: Can be ordered with standard pre-finish or with any other suitable finish applied at the factory.



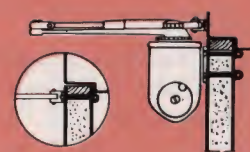
CYLINDRICAL LOCK SET



HALF SURFACE HINGE



FULL MORTISE HINGE



DOOR CLOSER

It is required by Underwriters' Laboratories, Inc., that mortise hinges for wood covered fire doors be secured to door with No. 12 x $1\frac{1}{4}$ " self-tapping sheet metal screws, and surface hinges be applied with steel through bolts.

Algoma-Made Doors

Weldwood Custom Royal Doors

decorative high pressure laminate faces on Stay-Strate or Staved Lumber Core constructions for interior use

FEATURES

1. Faces: High pressure laminate faces of your selection in decorator colors and patterns.
2. No on-the-job finishing.
3. As easily maintained as a high pressure laminate faced counter-top.
4. Hang as an ordinary flush door.
5. Push plates and kick plates not required.
6. All standard Weldwood door sizes and styles available.

SUGGESTED SPECIFICATIONS

All doors as indicated shall be Weldwood Custom Royal Doors with high pressure plastic laminate on (specify Stay-Strate, Staved Lumber Core construction), as manufactured by United States Plywood, and shall be guaranteed for interior use in the same manner as their constructions.

Faces: Faces shall be 1/16" thick high pressure plastic laminate. (Specify Westinghouse Mi-

carta, Formica or other manufacturer, and his number or color.)

Edge Strips: Edge strips shall be 1/16" thick (select: high pressure plastic laminates same as face or hardwood suitable for staining or painting) securely bonded to edge bands.

Adhesives: All glues are thermo-setting plywood adhesives (gap-filling and craze-resistant), equal to or exceeding commercial standards.

Light and Louver Openings: Where specified, doors shall be provided with light and louver openings (in accordance with the Weldwood Standard Details which include circular, rectangular and divided), by the door manufacturer. Beads, moldings and louvers to be of wood to match or blend with high pressure plastic laminate door face.

Prefit: All doors shall be trimmed square for standard book sizes, or trimmed for prefit specifications and edges beveled as desired. (Except: doors banded with high pressure plastic laminate must be specified for exact net width and length.)

Delivery: Each Custom Royal door shall be individually wrapped in carton before shipment from Algoma plant.

With Stay-Strate Construction

Core: The core shall be Weldrok incombustible mineral composition of 22 lb./cu. ft. nominal density, pieces securely bonded together with waterproof adhesive.

Matching Edges: 1. High pressure plastic laminate to match door face, or 2. Hardwood

for staining or painting to match.

Sizes: Door Size — shall be available 1 1/8", 1 3/8", 1 3/4", 2" and 2 1/4" thick in a wide range of sizes. Doors banded with high pressure plastic laminate edges to be (indicate net width and length) and edges beveled.

Crossbands: Crossbands shall be 1/16" hardwood next to the core, and 1/12" long grain, before sanding, next to the high pressure plastic laminate, extending full width and length of the door.

Edge Bands: Top and bottom rails shall be thoroughly kiln dried hardwood, 4 3/8" wide, built up of stock securely glued together. Stiles shall be thoroughly kiln dried hardwood, 1 3/8" wide, built up of two pieces of stock securely glued together.

Lock Blocks: Two lock blocks, one at each edge of door, each 3-13/16" wide, 35 3/8" long, not less than 22-3/16" from bottom of door. Inside edge not less than 5-3/16" from edge of door.

With Staved Lumber Core Construction

Core: Core shall be built up of narrow pieces of Pine, or equal, installed vertically, with grains alternated to provide dimensional stability.

Crossbands: Crossbands shall be 1/12" hardwood extending full width of door.

Edge Bands: Top and bottom rails shall be thoroughly kiln dried hardwood, on edge, laminated to the core.

Algoma-Made

Weldwood Duraply® Exterior Door

Stay-Strate and Staved Lumber Core Constructions, Duraply-2-Sides; Duraply-1-Side, Hardwood-1-Side.

Added protection from elements. CreZon® faces, same as for painted boat hulls, will not check. Excellent paintability — prime and two finish coats of good paint can last 4 to 5 years. Stiles and rails of Cedar Heartwood, well-known for resistance to rot and decay. Greater dimensional stability due to added CreZon face(s). Economical — maintenance and adjustment much less than for thicker-faced wood doors. Guaranteed for Life of Installation — ask for particulars.

Construction

7-PLY — CreZon facing each side of Algoma-made 5-ply door (sound Birch or Maple inner-face).

Cores

Stay-Strate—Weldrok, incombustible mineral core.

Staved Lumber — Low-density, properly kiln dried wood blocks (not more than 2300 lbs./1000 board ft., 6% moisture content).

Edge Bands—Cedar Heartwood for extra

resistance to decay, etc., and good screw holding.

Stay-Strate — 1 3/8" stiles, 4 3/8" glued-up top and bottom rails, with solid exposed edges.

Staved Lumber—1 3/8" solid stiles and rails.

*CreZon is a registered trademark of the Crown Zellerbach Corporation.

PERMAPLY® EXTERIOR DOORS — To be specified where hi-density overlaid surfaces are desired on Stay-Strate or Staved Lumber Core constructions.

SUGGESTED SPECIFICATIONS

SHORT SPECIFICATION: All exterior flush doors (as indicated) shall be Weldwood Duraply 7-ply Stay-Strate (mineral core) construction, as manufactured by United States Plywood Corporation.

LONG SPECIFICATION: All exterior flush doors shall be Weldwood Duraply Stay-Strate construction as manufactured by United States Plywood Corporation. Faces shall be medium density CreZon fused to an inner-face of Sound Birch or Maple standard thickness face veneer. Crossbands shall be kiln dried hardwood 1/16" thick extending the full width of the door with the grain at right angles to the face veneers.

Cores

Stay-Strate construction: Core shall be of Weldrok (all inorganic materials based on calcium silicate with asbestos fibers), with 22# nominal density. Each core shall be made of three or more pieces securely bonded together by the high frequency gluing process. Top and bottom rails shall be glued up of Heartwood Cedar properly dried 4 3/8" wide. Side edge bands or stiles shall be solid Heartwood

Cedar 1 3/8" wide. Two lock blocks 3-13/16" wide and 35 3/8" long shall be installed on two sides. The inside edge of lock blocks shall not be less than 5-3/16" from outer edge of door. Minimum distance from bottom of lock block to bottom of door shall be 22-3/16".

Staved Lumber Core construction: Core shall be made of kiln dried low density narrow wood blocks of varying lengths. Stiles, top and bottom edge bands shall be 1 3/8" wide, kiln dried solid Heartwood Cedar.

Light and Louver Openings

Stay-Strate construction: When indicated on the plans, light and louver opening shall have a concealed banding 1 3/8" wide Heartwood Cedar properly dried. Balance of light detail (bars, beads and louvers) shall be preservative treated Pine in accordance with Weldwood details. Glass beads for light openings shall be provided tacked in loose.

Staved Lumber Core construction: Where indicated on plans, preservative treated lights and louvers manufactured of Pine, in accordance with Weldwood details shall be provided. Glass beads for light openings shall be tacked in loose. Aluminum flashing shall be provided for all exterior lights and louvers.

Crossbands and faces shall be laminated to the core with 100% waterproof resin glue, by the hot plate process.

All doors shall be guaranteed against manufacturing defects and for performance for the life-of-the-installation, in accordance with the terms of the manufacturer's guarantee.

Where metal louvers are indicated, openings shall be properly sealed to prevent absorption of moisture.

All glazing and installation of metal louvers shall be done by others.

Special Doors

Weldwood Stile and Rail Core Door

Hardwood faced wood door
For exterior and interior use
Construction is preferred in some areas
as it closely conforms to
Federal Specification LLL-D-581,
Type I, Style II.

Wood Faces: Standard thickness, Birch
and other hardwood veneers selected for
grain figure and color, or special faces
to match architectural woodwork.

Core: Glued up core of varied length
Pine or equal species wood blocks, and
of stile and rail construction.

Hardwood Crossbands • Water-Resistant
Adhesive • Factory Machining and Fin-
ishing • Light and Louver Openings • All
standard sizes and thicknesses (see speci-
fications) • Doors trimmed to standard
book sizes

The Life of the Building Guarantee

Weldwood Stile and Rail Core Doors are manu-
factured to the highest standards of the industry
and under the most rigid quality controls. If
treated in accordance with the best carpentry and
finishing practices, the United States Plywood
Corporation will guarantee against manufacturing
defects and performance for the LIFE OF THE
INSTALLATION.

Weldwood Doors must not be structurally im-
paired by excessive trimming or manufacturing.
Immediately after fitting, they shall be finished
with exterior or interior varnish as required, or
painted on all four edges as well as the two faces.
Should any Weldwood Stile and Rail Core Door
prove unsatisfactory after installation, the United
States Plywood Corporation agrees, after inspec-
tion by an authorized representative, to replace
the door and allow costs of a reasonable nature
for rehanging and finishing.

SUGGESTED SPECIFICATIONS

SHORT FORM: All flush doors (as indicated)
shall be Weldwood Stile and Rail Core Doors,
as manufactured and guaranteed by United
States Plywood Corporation.

LONG FORM: All flush doors (as indicated)
shall be Weldwood Stile and Rail Core Doors,
as made and guaranteed by United States
Plywood Corporation.

Face Veneers: Face veneers shall be standard
thickness, thoroughly kiln dried hardwoods and
laid with the grain at right angles to the grain
of the cross bands. Standard thickness sliced
or rotary cut domestic or foreign woods. (Insert
species and any special requirements). Both
faces shall be smoothly sanded. Doors may
not be ready for painters' finish if subjected
to excess humidity and rough handling during
shipment and storage, and should be sanded
lightly with 00 sandpaper before finishing.

Cross Bands: Cross bands shall be thoroughly
kiln dried hardwood, 1/16" (or 1/10", where
specified) thick, extending the full width of
the door and laid with the grain at right angles
to the face veneers.

Core: Core shall be of glued up properly
kiln dried wood blocks, varied lengths of Pine
or equal species, and of stile and rail construc-
tion. It shall consist of three or more vertical
stave panels tongued, grooved and glued into
the stiles and cross-rails. The entire assembly
shall be glued with highly water-resistant glue.

Edge Bands: The stile edge bands shall be
thoroughly kiln dried 3/4" hardwood to match
the faces. All edge bands shall be laminated
to the core with highly water-resistant glue.

Adhesive: Cross bands and faces shall be
laminated to the cores with highly water-
proof glue.

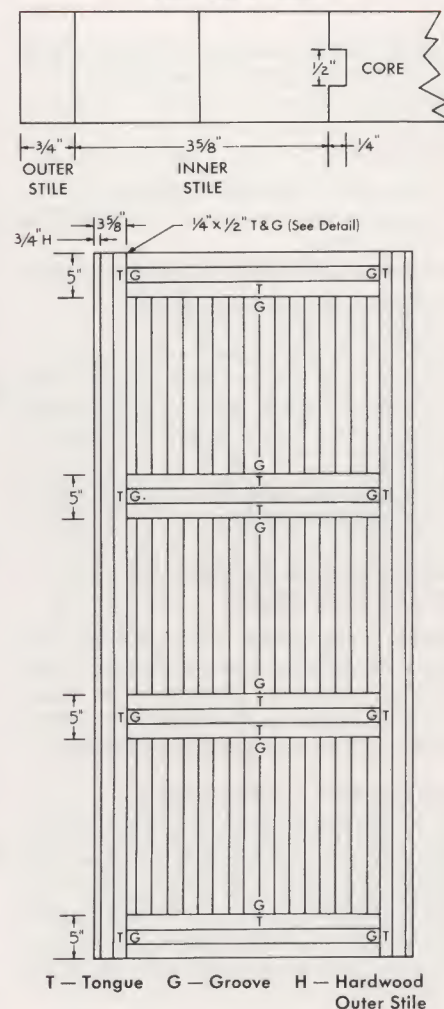
Sizes: Doors shall be available in a wide range
of sizes and thicknesses. 1 3/8", 1 3/4", 2" and
2 1/4" thicknesses are available, as well as 1 1/8"
and 1 1/4" stall doors. The Life of the Installation
Guarantee covers doors up to 4/0 x 7/0, which
are normally considered stock. Sizes up to 6/0
x 12/0 are available, not covered by standard
guarantee.

Prefit: All doors shall be trimmed square and
to standard book size, or prefit to net size.

Factory Machining and Finishing: May be
specified.

Light and Louver Openings: Where specified
(indicate size and location) doors shall be pro-
vided with light and louver openings (with
metal flashing specified for exterior doors),
in accordance with Weldwood details which
include circular, rectangular and divided lights
and wood louvers. Glass beads for light open-
ings shall be provided tacked in loose. All glaz-
ing and installation of metal louvers shall be
done by others.

**TONGUE & GROOVE DETAIL
from top of door**



Weldwood Architecturally-Designed Doors

United States Plywood Corporation, on order, manufactures varia-
tions of standard Weldwood designs for special applications, such
as doors with Gothic, segment, and circle-top heads, as well as
with special light openings, etc., consistent with the architect's
desire for the unusual.

**Algoma-Made
Weldwood
Special-Purpose
Doors**

Metal Surface-Protective Plates — Any
Weldwood flush door can be specified
metal-faced or with metal, usually stain-
less steel, kick plates, push plates, etc.,
to withstand exceptional abuse as ex-
pected at service entrances to kitchens,
hotels and hospitals; and entrances to load-
ing platforms at warehouses and plants.

X-Ray Doors — Lead-Lined doors, for use
in hospitals, clinics, doctors' offices, lab-
oratories and industrial areas.

Louver Doors — Decorative wood-louvered
doors permit full air flow, yet offer pri-
vacy and security for all types of resi-
dences, commercial and office buildings,
plants, public buildings, summer resort
buildings, etc.

Hospital Doors — Long wearing Stainless
Steel stretcher and kick plates on any
Algoma-Made Weldwood Door assure
years of maintenance-free beauty despite
continual impact and abrasion.

Algoma-Made **Weldwood Acoustical Doors**

1 3/4" DOOR Sound Transmission Class-36

2 1/2" DOOR Sound Transmission Class-40

1 3/4" DOUBLE DOOR Sound Transmission Class-51

Ratings established as operating units to ASTM E90-61T adopted 1955 and as revised 1961

Algoma-Hardwood Faced or Plastic Faced
 Flush Door. Standard Sizes to Fit
 Standard Bucks

FEATURES

- Faces are Algoma hardwoods.
- Construction guaranteed for the life of the building.
- Factory and custom finishing available.
- Factory machining available.
- Light openings available.
- Standard book sizes to 4/0 x 8/0.
- Simple installation—light weight—hang as regular flush doors with furnished accessories, and standard hardware by others.
- Completely reversible for Right-Hand or Left-Hand swing.

THOROUGHLY TESTED AS OPERATING DOORS

Sound Transmission Loss Ratings have been established in accordance with ASTM Procedure (E90-61T) at Riverbank Acoustical Laboratories, the testing facility of the Acoustical Door Institute.

EXCELLENT APPEARANCE

As for the Weldwood Algoma-Made Fire, Stay-Strate, and Staved Lumber Core Doors, domestic and exotic hardwoods are available to match or blend with other architectural hardwoods in the area (doors, paneling, woodwork, etc.) Also

available as Weldwood Custom Royal Acoustical Door, with Micarta or other similar faces.

Finishing may be specified according to factory standards, or to satisfy custom specification.

Factory Machining may be ordered to match door and hardware schedules, and with light openings for glazing by others.

FOR CRITICAL AREAS

Where the ultimate in sound transmission loss is required, Weldwood Acoustical Doors may be hung double with 3" or greater air space between doors. Test results indicate such installation to be almost as effective as a 16" concrete wall.

Simplified detail is included on this data sheet for explanation only. Complete detail and specification will be furnished as required.

SIZES AND WEIGHTS

1 3/4" thick door weighs 6.5 lb./sq. ft.; 2 1/2" thick, 8.4 lb./sq. ft. Both are available in all book sizes as large as 4/0 x 8/0.

ACCESSORIES

AUTOMATIC DROP SEAL (included in package). Install bottom seal in strict accordance with complete, detailed instructions in package.

DOOR STOPS (included in package). Miter stops, leaving gasketing slightly longer than wood member, to required length and install so that synthetic gasketing is compressed 1/32" against closed door.

ASTRAGALS FOR DOORS HUNG IN PAIRS (available from door manufacturer). Mount synthetic rubber gasketed astragal on inactive door to seal both leading edges of closed doors.

HARDWARE

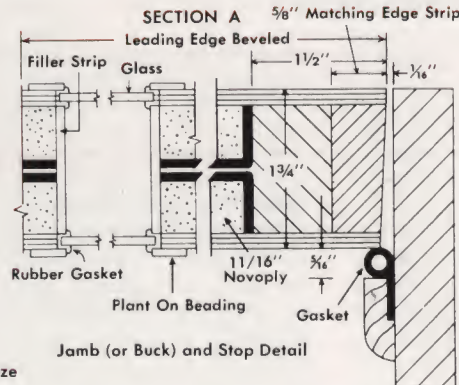
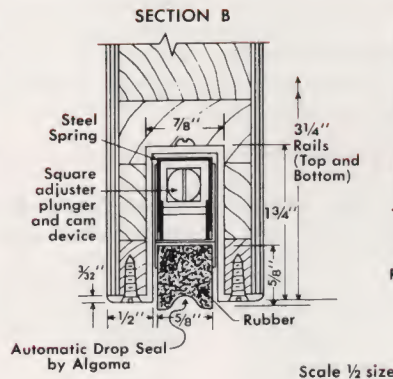
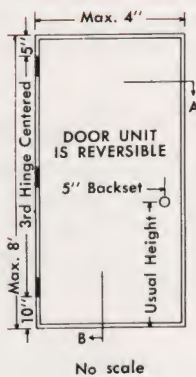
BUTT HINGES 4 1/2" x 4 1/2" minimum, BB preferred, three per door positioned in accordance with standard practice, with one hinge centered. Doors 7/6 and larger use four hinges.

LOCK SETS. *Cylindrical* (preferred) or mortise lock sets, with either standard or 5" back-set.

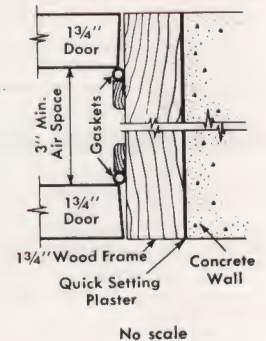
ACOUSTICAL DOOR INSTITUTE

United States Plywood is a member of Acoustical Door Institute. This national organization has been established by manufacturers of acoustical doors to 1—cooperate with architects and engineers in solving problems of insulating against sound, and 2—provide standardization of tests for a comparison of acoustical doors.

Installation



Double Door Installation



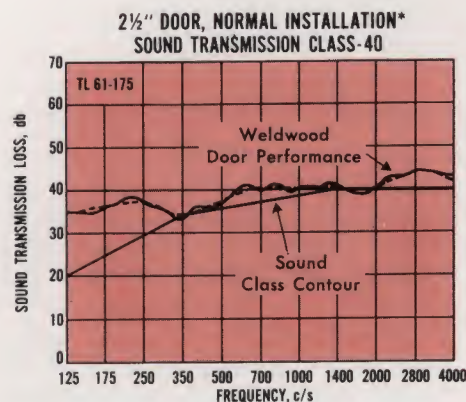
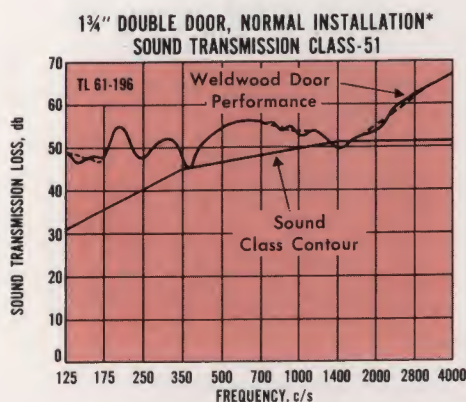
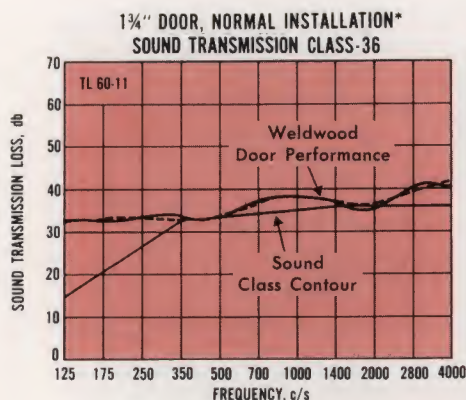
Sound Transmission Loss Ratings —Tested as Operating Doors

Sound transmission class is designed to supercede the previous nine frequency average sound transmission loss, and is determined by the new ASTM Designation E 90-61T which supercedes ASTM E 90-55. The advantage of sound transmission class is that the average loss of the specimen cannot be bolstered by unusual performance at the extremes of the frequency range which are not too important.

The specimen's transmission loss curve must be on or above the middle section (350 to 1400 cps) of the class contour while it can be below as much as 3 db at any one frequency. On each end the average deficiency must be no more than 1 db.

We have adopted the modern sound transmission class designation, but for comparison purposes we will give the sound transmission loss average of the nine frequencies. The preferred criteria based on door requirements in typical architectural applications is the sound transmission class.

This combination of independently operated doors is actually more effective than an 8" concrete wall, almost as good as a 16" concrete wall. Test installation was with two 1¾" Weldwood Acoustical Doors with standard accessories, installed in wood frame cemented into 16" concrete wall, 8" air space between doors. For equal efficiency, at least 3" air space between doors should be maintained (with door knobs at different levels, when necessary, for clearance).



*Average 1¾" Panel Value is 37.5db, with the Acoustical Door tested as a completely sealed-in panel; Average 2½" Panel Value is 40.4db; Average Double 1¾" Panel Value is 55.0db. The operating

values of the Weldwood Acoustical Door are remarkably close to its sealed-in Panel Values. This attests to the value of the recommended installation procedures and to the effective design of the standard bottom seal, synthetic rubber stops and astragals.

Life-of-the-Building Guarantee

United States Plywood Corporation unconditionally guarantees the Weldwood Acoustical Door against warping, twisting, or manufacturing defects for the Life Of The Installation, when accorded treatment which is considered good practice, as far as storage, installation and maintenance are concerned. If any Weldwood Acoustical Door should fail to meet these standards, we will replace said door without charge, including all labor costs of hanging and refinishing involved.

SPECIFICATIONS

Sound insulating doors as indicated on the plans shall be Weldwood Acoustical Doors (1¾" thick with a Sound Transmission Class-36) (2½" thick with a Sound Transmission Class-40) as manufactured by United States Plywood Corporation. Doors shall be 7-ply construction consisting of 3-ply skins, face ply to be (state species). Skins, to which 11/16" Novoply has been bonded with resin glue by the hot plate method, shall be applied to frame. Doors shall be furnished complete with automatic threshold sealing device, gaskets, and stops.

All doors shall be guaranteed against manufacturing defects and for performance for the life-of-installation, in accordance with the terms of manufacturer's guarantee. When requested, the contractor shall submit a certification from the manufacturer substantiating the sound transmission class based on Riverbank Acoustical Laboratories tests shown herein, run in accordance with ASTM E90-61T. Riverbank Acoustical Laboratories is the official testing laboratory for the Acoustical Door Institute.

Glazing: Matching wood light openings can be furnished with gasketing and stops for double ¼" Plate Glass glazing. (Glass by others.) Openings must not be less than 6" from any edge of door and not exceed 40% of door area. No special blocking required.

Factory Machining and Finishing: May be specified.

Solid-Core Door, Mengel-Made

Interior and exterior door, engineered for extreme stability and flatness. Cross-banding and face veneers are chosen for uniformity and minimum reaction. Changes of moisture cannot significantly change overall door dimensions: core butt joints are staggered and space for core pieces to expand and contract individually is provided. Dove-tail corner joints provide great rigidity. All bonding is under heat and pressure with waterproof adhesive.

Matching stile edges supplied unless otherwise specified.

Special purpose assemblies (lead-lined, etc.) available.

Sizes to 4/0 x 8/0. 1 $\frac{3}{8}$ " , 1 $\frac{3}{4}$ " and thicker. Light openings and/or louvers available per details.

Guaranteed—covered by National Woodwork Manufacturers Association standard guarantee.



Permadoor, Mengel-Made

guaranteed in writing
for the life of the installation

Engineered identically to the Solid-Core Door, Mengel-Made, except that every component is especially selected. Manufacturing is to the most exacting standards, with extra inspections of material and workmanship. Each door's "life record" is kept in detail. Written Lifetime Guarantee is issued for each door, by Serial Number.

Guarantee

United States Plywood guarantees its solid core Weldwood Permadoors, Mengel-Made, for the life of the original installation, provided they are properly handled, hung, finished and maintained.

If any defects develop in material and/or workmanship and, after inspection by an authorized representative, it is agreed that doors have been properly handled, hung, finished and maintained, they will be replaced without charge. This replacement will include reasonable costs for rehanging and refinishing.

Guarantee period shall be for the life of the installation. Written guarantee shall be provided for each door, by Serial Number.

Institutional Hollow Core Door, Mengel-Made

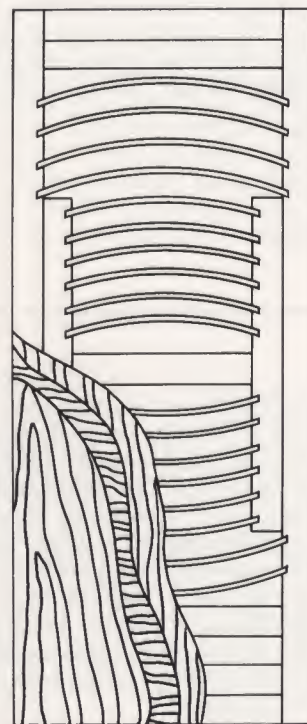
second only to solid-core doors
for heavy-duty interior and
exterior applications

Especially suitable for public buildings, etc. Light, durable, and immune to warping or buckling under normal conditions. Designed, engineered and constructed to the highest standards; quality-controlled throughout manufacture.

Construction is seven-ply, with reinforced frames. Double rails at the top, and quadruple rails at the bottom, provide solid backing for optional door closers and kick plates. Intermediate center rail for panic bars. 40" lock blocks on each side. Tight faces are insured: Core strips of extra-heavy, wood-derivative material are set under tension into notched stiles.

Sizes to 4/0 x 8/0. 1 $\frac{3}{8}$ " , 1 $\frac{3}{4}$ " and thicker. Light openings and/or louvers available per details.

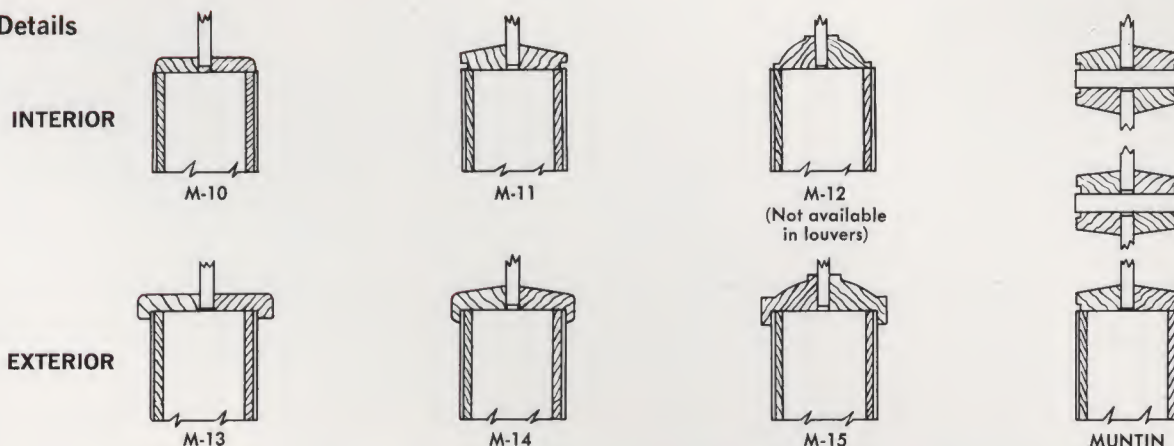
Guaranteed—covered by National Woodwork Manufacturers Association standard guarantee.



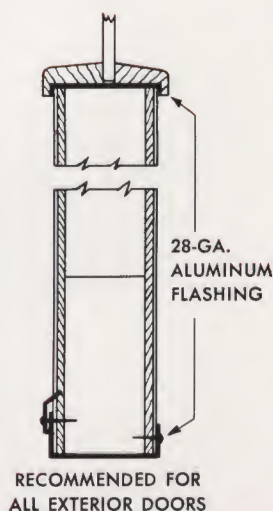
Standard Light and Louver Details for Weldwood Doors, Mengel-Made

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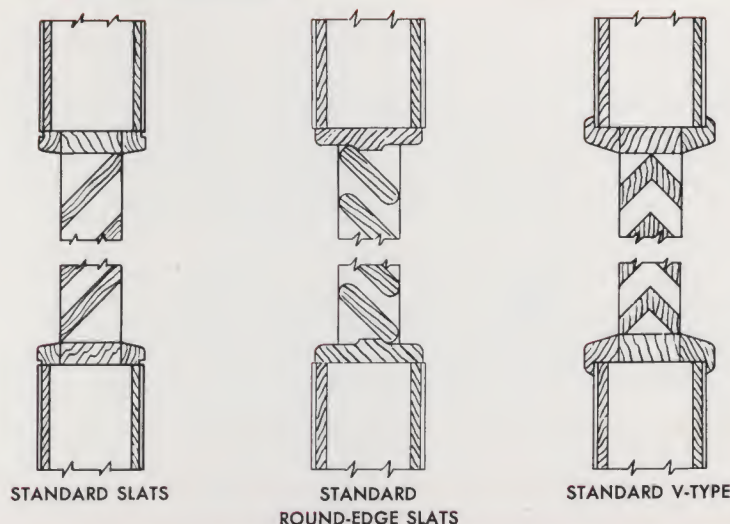
Standard Light Details



Flashing



Louver Details



RECOMMENDED SPECIFICATIONS

Solid-Core Door and Permadoor

GENERAL: All doors shall be five-ply, flush type (Weldwood Solid-Core Door, Mengel-Made) (Weldwood Permadoor, Mengel-Made, and guaranteed in writing individually according to serial number for the life of the installation). Stiles and rails shall have dove-tail joints at all four corners. Doors shall be constructed in strict accordance with Mengel Standard Construction, and shall meet or exceed requirements of Commercial Standard 171-58.

Cores: Cores shall be made up of properly kiln dried hardwood or softwood blocks no wider than 2" and of varying lengths, with grain running vertically. Cores will be of the framed strip type. For stability, core pieces will be non-edge glued.

Crossbands: Crossbands shall be thoroughly kiln dried hardwood veneers 1/10" thick, extending the full width of the door and laid with the grain at right angles to the face veneer.

Face Veneers: Face veneers shall be made of thoroughly kiln dried hardwoods of standard thickness, and laid with the grain at right angles to the grain of the crossbands. Doors will be ready for painter's finish (unless subjected to excess humidity, or rough handling).

Edge Bands: The stiles shall have an overall

width of 1 1/8" or more, with laminated matching edges at least 1/2" wide after trimming. The rails shall be at least 2 1/2" wide, made of thoroughly kiln dried hardwood or softwood.

Adhesive: Crossbands and faces shall be laminated to the cores with 100% waterproof resin glue, by the hot plate process.

Prefit: All doors shall be trimmed square to standard sizes, or prefit to net sizes.

Light and Louver Openings: Where specified, doors shall be provided with light and louver openings in accordance with published Standard Details. Beads shall be provided when specified and shall be tacked in loose.

Institutional Door

GENERAL: All doors shall be seven-ply, hollow core, flush type, Weldwood Institutional Doors, Mengel-Made. Doors will be constructed in strict accordance with Mengel Standard Construction and shall meet or exceed requirements of Commercial Standard 171-58.

Cores: Cores shall be ladder type with core strips made from a wood derivative and uniformly spaced 3" on center for interior and exterior use. All core parts or members shall be bonded to face panels.

Face Panels: Face panels shall be three-ply con-

struction, made up of standard thickness veneers, and shall be 1/8" thick over all before sanding. Face veneers shall be sanded smooth according to Mengel standards. Doors will be ready for painter's finish (unless subjected to excess humidity, or rough handling).

Frame: Stiles and rails shall be made of softwood. The combined width of the two top rails shall be nominal 6", and combined width of the four bottom rails shall be nominal 12".

The stiles shall be nominal 3" wide. When specified, matching hardwood edge strips shall be laminated to the stiles and shall be 1/2" wide after trimming.

The intermediate rail shall be nominal 3" wide and the center of the rail shall be 40" from the bottom of the door.

Lock Blocks: Lock blocks shall be made of softwood and shall be nominal 3" wide (nominal 6" including stile) and 40" long, centered on both sides.


Adhesives: All adhesives shall conform to Commercial Standard 171-58, Type I or Type II, as specified.

Sizes: (Produced in all standard sizes, 1 3/4" or 1 3/4" thickness.)

Prefit: All doors shall be trimmed square to standard sizes, or prefit to net sizes.

Weldwood Doors

 **Algoma-Made**

 **Mengel-Made**

... the complete line of hardwood-faced flush doors
... for interiors and exteriors of all types of buildings

For practically any condition of exposure and traffic, there is a standard Weldwood Door construction. For interiors and exteriors. For fire barrier. For sound control. Hardwood, plastic laminate, and paint-grade and special faces. On mineral or wood or hollow cores. In grades to match architectural woodwork or to satisfy less demanding requirements. Even in 'specials' where the unusual is desired in appearance or in construction.

For the benefit of architect, designer, and owner, Weldwood plants offer complete light and louver detailing and machining and finishing services. Control of appearance and fit remains with the architect: with a quality of materials and finish and workmanship that cannot be duplicated in the field. Doors arrive on the job ready for hanging. No matter what the weather or labor situation, there is no sacrifice of building schedule. (See pages 3-8 of this catalog.)

Each and every Weldwood Door is specifically guaranteed for structural integrity and for performance ... most guarantees are for the Life-Of-The-Building ... by United States Plywood.

This catalog contains sufficient information on Weldwood Doors for comparison and specifying and detailing. For any further data, contact the United States Plywood branch office nearest you, or write direct.

ALGOMA-MADE WELDWOOD DOORS

Especially recommended for use where uncompromising standards for appearance, 'feel', and performance have been established.

Weldwood "Stay-Strate" Door ... page 9

Hardwood-faced interior/exterior architectural door, especially recommended for use with architectural woodwork. Appearance of its hardwood faces, and the stability of its inert mineral core, are equalled only by Weldwood Fire Doors. Registered Lifetime Guarantee issued by serial number.

Weldwood Staved Lumber Core Door ... page 10

Hardwood-faced all-purpose interior/exterior door, particularly recommended for use with tasteful decorating such as Algoma-Made hardwood plywood wall paneling.

Weldwood Fire Doors ... page 11, 12, 13

Hardwood or plastic laminate faces. Labelled for 1-hour

and ¾-hour. For use where doors must have the appearance of architectural hardwood faces plus the protection of a rated fire door.

Weldwood Custom Royal Door ... page 14

Plastic laminate faced Stay-Strate or Staved Lumber Core Door constructions. Hang as any comparable quality hardwood-faced flush door.

Weldwood Duraply Exterior Door ... page 14

Non-checking, excellent paint surface on stable Stay-Strate or Staved Lumber Core constructions.

Weldwood Permaply Exterior Door ... page 14

High-density overlaid surfaces on Stay-Strate or Staved Lumber Core constructions.

Weldwood Stile and Rail Core Door ... page 15

Exterior/interior hardwood-faced door ... closely conforms to Federal Specification LLL-D-581, Type I, Style II.

Weldwood Architecturally-Designed Doors ... page 15

Doors for special applications, employing variations of Weldwood standard specifications for machining and finishing, and light and louver detailing.

Weldwood Special-Purpose Doors ... page 15

X-Ray, Hospital, etc., doors of Algoma quality constructions that have been redesigned for specific uses, including doors with metal surface-protective plates.

Weldwood Acoustical Doors ... pages 16, 17

1¾" and 2½" thick, hardwood-faced flush doors to fit standard bucks. Simple installation. Hang as any regular flush doors.



MENGEL-MADE WELDWOOD DOORS

Solid-Core Door ... page 18

Interior/exterior hardwood faced flush door with dove-tail corner joints for great rigidity.

Permadoor ... page 18

Same engineering as Solid Core Door but with specially-selected components and written Life-Of-The-Building guarantee.

Institutional Hollow Core Door ... page 18


Second only to solid-core doors for heavy duty applications.

Weldwood Doors United States Plywood

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Over 140 offices in United States and Canada
in Canada: WELDWOOD-WESTPLY LIMITED

Weldwood Doors

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. . . the complete line of hardwood-faced flush doors
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of a rated fire door.

Weldwood Custom Royal Door . . . page 14

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